

Work Order ID 125633

October-17-14 10:18:16 AM

125633

Page 1

Item ID: D206-642-541

Accept

N9000040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Replacement Skidtube, High Gear, Standard Wearplates Fits LH or RH, DART (Apical)
Tri-Bag Float Comp

Start Date: 10/17/14 Start Qty: 1.00

1

Cost Item ID:

Required Date: 11/07/14 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run

Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Description

Total ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Station

Draw Nbr

Revision Nbr

D3274-041

F

100

Document Control

0.00

100

DOCUMENT CONTROL

DC

Memo

0.00

Doc. Control -USB or Paperwork

Photocopy bluefile & type labels per PPP D206-642-541

CHG005

N/A

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Item ID: D206-642-541

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Replacement Skidtube, High Gear, Standard Wearplates Fits LH or RH, DART (Apical)
Tri-Bag Float Comp

Start Date: 10/17/14 Start Qty: 1.00 *1*

Cust Item ID:

Required Date: 11/07/14 Req'd Qty: 1.00 *1*

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start *NR1*

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Time	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Status
--------------------------------	--------------------------	-----------------	---------	--------	--------------	---------------	---------------	------------------	-----------------

110

Skidtubes

Skidtubes

Memo

0.00

****VERIFY AND INSPECT THE MATERIAL PRIOR TO USE****

1- remove fwd indexing ridge as per dwg D3274. Prepare for welding

2- weld fwd cap as per dwg D3274 and QSI004

AR Aluminum Rod Batch: M130137

3- grind fwd cap weld on top surface only

4- Cut AFT end of tube at 170.9" as per dwg D3274 and deburr end.

5-Drill Aft cap pilot hole using DT8025

6 -Cleco DT8025 in position and install pilot hole drill jig DT8742A,B,C,D and DT8742. Drill 3/16" pilot holes as per Dwg D3274

7 -Remove inner indexing ridge on aft end of skidtube as per Dwg D3274 scribe batch #

8 -Open aft end cap holes to Ø0.208" as per Dwg D3274. Deburr aft end.

3 OCT-10-27

DGC 14-10-28

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Item ID: D206-642-541

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Item Name: Replacement Skidtube, High Gear, Standard Wearplates Fits LH or RH, DART (Apical)
Tri-Bag Float Comp

Stop ***NS2***

Start Date: 10/17/14 Start Qty: 1.00

1

Cust Item ID:

Required Date: 11/07/14 Req'd Qty: 1.00

1

Customer:

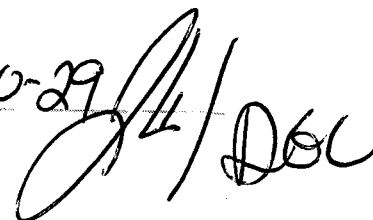
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start ***NR1***

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Time	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Reason	Insp. Status
114	QC5- Inspect part completeness to step on W/O	0.00							
114									
QC	Memo	0.00				①	14-10-29		DAS 9 9-89
Quality Control									
116	QC10- Inspect visual per QSI004- ground welds	0.00							
116									
QC	Memo	0.00				①	14-10-29		DAS 9 9-89
Quality Control									
120	Chemical Conversion Coat per QSI005 4.1	0.00							
120									
HandFinish	Memo	0.00							
Hand Finishing									

14-10-29  DOL

Work Order ID 125633

October-17-14 10:18:16 AM

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Item ID: D206-642-541

Accept

N900040100Setup Start ***NS1***

Revision ID:

Item Name: Replacement Skidtube, High Gear, Standard Wearplates Fits LH or RH, DART (Apical)
Tri-Bag Float CompStop ***NS2***

Start Date: 10/17/14 Start Qty: 1.00

1

Cust Item ID:

Required Date: 11/07/14 Req'd Qty: 1.00

1

Customer:

Reference:


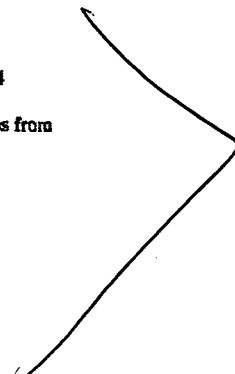
Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Time Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Status
130	QC7-Inspect Chemical Conversion Coat	0.00							
130									
QC	Memo	0.00							
Quality Control									
150		0.00							
150									
Skidtubes									
Skidtubes	Memo	0.00							
Skidtubes	1-Open Ø0.313" and 0.375" crossbolt spacer holes as per Dwg D3274								
	2-Deburr crossbolt spacer holes as per Dwg D3274 and blow out chips from inside the tube								
	3-Bond web in place as per Dwg D3274 & QSI 015.								
	A/RSikaflex-291 <u>130227</u>								
	Sikaflex expire date: <u>15-02-05</u>								
	Start: _____ Time: <u>11:00AM</u>								
	Finish: _____ Time: _____								
	(Adhere for 12 hours)								

 14-10-30 DGC 14-10-30

Work Order ID 125633

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Item ID: D206-642-541

Accept

N9000040100

Setup Start *NS1*

Revision ID:

Item Name: Replacement Skidtube, High Gear, Standard Wearplates Fits LH or RH, DART (Apical)
Tri-Bag Float Comp

Stop *NS2*

Start Date: 10/17/14 Start Qty: 1.00

1

Cost Item ID:

Required Date: 11/07/14 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/
Work Center ID
160

Operation

Description

QCS- Inspect part completeness to step on W/O

Set Up/
Down Time

0.00

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Status

160

QC

Quality Control

Memo

0.00

1 0 14-11-03

170

170

Skidtubes

Skidtubes

Skidtubes

Memo

0.00

1-Bend AFT end of tube using bend prog. D3274 AFT as per dwg D3274. Install drop pins in crossbolt spacer holes to maintain web position.

2- DRILL PILOT HOLES FOR WEARPLATES USING D3274-1T2
OPEN HOLES TO .297". Deburr DO NOT DRILL HOLES
FOR WAVE WEAR PLATES.

3-DRILL TOE PIN HOLE .640" DIA AS PER DWG USING DTE935 FWD
END OF TUBE
DEBURR INSIDE OF HOLE AS NECESSARY (DO NOT ENLARGE HOLES)
REMOVE ANY FOREIGN OBJECTS INSIDE OF TUBES

4- Countersink crossbolt spacer holes as per Dwg D3274

5- prepare for welding

14-11-30 1/2000

BE14-11-03

DAS
18
9-89

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Item ID: D206-642-541

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2Item Name: Replacement Skidtube, High Gear, Standard Wearplates Fits LH or RH, DART (Apical)
Tri-Bag Float Comp

Start Date: 10/17/14 Start Qty: 1.00

1

Cust Item ID:

Required Date: 11/07/14 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run

Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2Sequence ID/
Work Center ID
180

Operation

Inspection
QC5- Inspect part completeness to step on W/OSet Up/
Time

0.00

Tool ID

Tool # Plan

Code

Accept

Qty

Reject

Qty

Reject

Number

Insp.

Stamp

180

QC

Memo

0.00

Quality Control

DP 14-11-3

190

0.00

190

Skidtubes

Skidtubes

Memo

0.00

Skidtubes

1-Insert D2649 & D3275-1 crossbolt spacers. Weld as per QSI 004 and Dwg D3274. Remember to back drill each hole before welding the other side. Use aluminum rod
A/RAluminum Rod M130137

BE 14-11-03

3-Grind cross bolt welds flush as per Dwg D3274.
****INSPECT FOR PIN HOLES IN WELD****

4-Counterbore 5/16" x 0.750" deep as per Dwg D3274 and deburr.

DP 14-11-4

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Item ID: D206-642-541

Accept

N9000040100

Setup Start *NS1*

Revision ID:

Item Name: Replacement Skidtube, High Gear, Standard Wearplates Fits LH or RH, DART (Apical)
Tri-Bag Float Comp

Stop *NS2*

Start Date: 10/17/14 Start Qty: 1.00

1

Cust Item ID:

Required Date: 11/07/14 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/
Work Center ID
200

Operation

Description

Set Up/
Time

0.00

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
New Item

Insp.
Status

DAS

9

9-89

200

QC

Quality Control

Memo

0.00

① 14-11-05

210

QC10- Inspect visual per QSI004- ground welds

0.00

210

QC

Quality Control

Memo

0.00

① 14-11-05

DAS

9

9-89

220

Pressure Wash per QSI005 4.3

0.00

220

HandFinish

Hand Finishing

Memo

0.00

Re-alodine tube as per QSI 005 section 4.1.2.1 do not acid etch

14 / 11 / 06

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Item ID: D206-642-541

Accept

N9000040100

Setup Start *NS1*

Revision ID:

Item Name: Replacement Skidtube, High Gear, Standard Wearplates Fits LH or RH, DART (Apical)
Tri-Bag Float Comp

Stop *NS2*

Start Date: 10/17/14 Start Qty: 1.00 *1*

Cust Item ID:

Required Date: 11/07/14 Req'd Qty: 1.00 *1*

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start *NR1*

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Time	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
230		0.00							
230									
SprayPaint	Memo	0.00							CR 14.11.19
Spray Painting	Make sure Nut Plate Thread is protected using paint screw.								
	1- PRIME AS PER DWG AND QSI 005 4.2								
	USE:								
	PRC Desoto Primer 515X349 (Boeing Spec BMS 10-79 Type III Class A Grade								
	A) PRIME INSIDE AND OUTSIDE OF TUBE								128975 CR 14.11.08
	2-SPRAY PAINT PER QSI								
	USE: CA 8213/F37038 CAMOFLAGE								
	BLACK - MIL-PRF-05285E, TYPE I, CLASS H								130 804
240	QC14- Inspect Spray Paint	0.00							
240									
QC	Memo	0.00							
Quality Control									

DAS
15
9-89

1 x 4 21 14/11/19

Work Order ID 125633

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Item ID: D206-642-541

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Replacement Skidtube, High Gear, Standard Wearplates Fits LH or RH, DART (Apical)
Tri-Bag Float Comp

Start Date: 10/17/14 Start Qty: 1.00 ***1***

Cust Item ID:

Required Date: 11/07/14 Req'd Qty: 1.00 ***1***

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start ***NR1***

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Time	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Reason	Insp. Comments
244	Wing Walk as per dwg QSI005 4.4 Batch 1113075	0.00				1x	1	11	11/11/14
244	HandFinish								
	Hand Finishing								
246	QC3- Inspect Part Finish	0.00							
246	QC								
	Quality Control								

DAS
38
9-89

14-11-21

Work Order ID 125633

October-17-14 10:18:16 AM

125633

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Item ID: D206-642-541

Accept

N9000040100

Setup Start *NS1*

Revision ID:

Item Name: Replacement Skidtube, High Gear, Standard Wearplates Fits LH or RH, DART (Apical)
Tri-Bag Float Comp

Stop *NS2*

Start Date: 10/17/14 Start Qty: 1.00 *1*

Cust Item ID:

Required Date: 11/07/14 Req'd Qty: 1.00 *1*

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start *NR1*

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Status
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	-----------------

250

HandFinish

Hand Finishing

HandFinishing

Memo

0.00

1-Install Nut Plate as per Dwg D3274. Apply LPS-PROCYON to Nut Plate and rivets.

A/RN/ALPS-PROCYON 14122460

2-Install inserts as per Dwg D3274. Use a drop of Sikaflex inside insert holes a

A/RSikaflex-291

Sikaflex expire date: 12/6/14

260

QC5- Inspect part completeness to step on W/O

0.00

260

QC

Quality Control

Memo

Inspect Nut Plate & Inserts

0.00

1 14-11-21 DAS 34 9-89

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Item ID: D206-642-541

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Item Name: Replacement Skidtube, High Gear, Standard Wearplates Fits LH or RH, DART (Apical)
Tri-Bag Float Comp

Stop ***NS2***

Start Date: 10/17/14 Start Qty: 1.00

1

Cust Item ID:

Required Date: 11/07/14 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/

Work Center ID
270

Operation

Description

Set Up/

Time

0.00

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Station

270

HandFinish

Hand Finishing

HAND FINISHING RESOURCE #1

Memo

0.00

1-Install wearpads & gaskets as per Dwg D3274.

DO NOT INSTALL
LONG WEARPLATES

2-Install ring as per Dwg D3274

A/R Sikaflex-291 11/12/89

Sikaflex expire date: 15/10/14

3-Inspect for foreign objects as per QSI 024

4-Install Aft Cap and seal with Sikaflex. Clean excess adhesive.

A/R Sikaflex-291 11/12/89

Sikaflex expire date: 15/10/14

280

QC5- Inspect part completeness to step on W/O

0.00

DAS

30

9-89

280

QC

Quality Control

Memo

0.00

14-11-21

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Item ID: D206-642-541

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Item Name: Replacement Skidtube, High Gear, Standard Wearplates Fits LH or RH, DART (Apical)
Tri-Bag Float Comp

Stop ***NS2***

Start Date: 10/17/14 Start Qty: 1.00 ***1***

Cust Item ID:

Required Date: 11/07/14 Req'd Qty: 1.00 ***1***

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start ***NR1***

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description Identify as per dwg & Stock Location: _____	Set Up/ Time Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Comments
290		0.00							
290									
Packaging	Memo	0.00							
Packaging					DAS				
					06				
					9-89				
300	QC21- Final Inspection - Work Order Release	0.00							
300									
QC	Memo	0.00							
Quality Control									

NOV 21 2014

14/11/21

4-11-21

Picklist Print

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Work Order ID: 125633

125633

Parent Item: D206-642-541

D206-642-541

Parent Item Name: Replacement Skidtube, High Gear, Standard Wearplates Fits LH or RH, DART
(Apical) Tri-Bag Float Comp

Start Date: 10/17/14

Required Date: 11/07/14

Comments:

IPP Rev:B05.09.23 Revised per D206-642 Rev. JKI/JLM
IPP Rev:C 07-02-23 Added SS Wearplates & Gaskets JLM
IPP Rev:D 07-12-06 replace NAS1515H3L to D3672-1 DD
IPP Rev:E 08-04-17 as per PAR 08-015 DD verified by:EC
IPP Rev:F 08-06-02 add comment DD verified by:EC
IPP Rev:G 08-10-09 revise details DD verified by:EC IPP
REV:H 13.09.05 CHG004/ BCN13-634 DD VERF:JLM IPP REV:I
14.04.28 AS PER BCN14-520 DD VERF:JLM

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3274-041BENT		Manufactured	No			110	Each	13.0000	1	1			
D3274-041BENT													
Skidtube Assembly 206													

BEH-D-27

Location	Loc Qty	Loc Code
LG	10	
LG002	10	
113682	3	
120287	1	
	2	

D4956-15	Manufactured	No	270	Each	23.0000	1	1		
D4956-15									
Stainless Steel Wearplate Fwd									
D4956-23									
Stainless Steel Wearplate Center Fwd									
D4956-23	Manufactured	No	270	Each	19.0000	1	1		
D4956-23									
Stainless Steel Wearplate Center Fwd									

N/A
NOT REQUIRED

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Parent Item: D206-642-541

Parent Item Name: Replacement Skidtube, High Gear, Standard Wearplates Fits LH or RH, DART
(Apical) Tri-Bag Float Comp

Start Date: 10/17/14

Required Date: 11/07/14

NOT
REDUMED

D3285-1

D3285-1

Cap

D3282-041

D3282-041

Float Web (206L/407)

Manufactured	No
1	1
2	1
3	1
4	1
5	1
6	1
7	1
8	1
9	1
10	1
11	1
12	1
13	1
14	1
15	1
16	1
17	1
18	1
19	1
20	1
21	1
22	1
23	1
24	1
25	1
26	1
27	1
28	1
29	1
30	1
31	1
32	1
33	1
34	1
35	1
36	1
37	1
38	1
39	1
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41	1
42	1
43	1
44	1
45	1
46	1
47	1
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61	1
62	1
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72	1
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74	1
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76	1
77	1
78	1
79	1
80	1
81	1
82	1
83	1
84	1
85	1
86	1
87	1
88	1
89	1
90	1
91	1
92	1
93	1
94	1
95	1
96	1
97	1
98	1
99	1
100	1

110

Each

30.0000

Location

LG

Loc 017

30

30

Each

Loc Code

1.0000

Location

LG002

Loc Qty

for

Index

Loc Code

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Parent Item: D206-642-541

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Parent Item Name: Replacement Skidtube, High Gear, Standard Wearplates Fits LH or RH, DART
(Apical) Tri-Bag Float Comp

Start Date: 10/17/14

Required Date: 11/07/14

D2649

Manufactured No

190

Each

Start Qty: 1.00
340.0000 12 12

Required Qty: 1.00

D2649

Cross Bolt Spacer

BE14-11-03

Location	Loc Qty	Loc Code
LG	128	
123099	128	
LG001	212	
107906	3	
112728	6	
113811	2	
120508	195	
90497	6	

D3275-1

Manufactured No

190

Each

117.0000 12 12

D3275-1

Crossbolt Spacer

BE14-11-03

Location	Loc Qty	Loc Code
LG001	117	
113246	1	
113851	62	
114877	1	
121858	1	
121974	52	

CR3212-4-03

Purchased No

250

Each

985.0000 2 2

CR3212-4-03

Cherry Rivet

all w/e/e/c

Location	Loc Qty	Loc Code
ST321	985	
114889	1	
119017	700	
m114859	100	
m123265	184	

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Shop Packet Print

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Picklist Print

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Parent Item: D206-642-541

D206-642-541

Parent Item Name: Replacement Skidtube, High Gear, Standard Wearplates Fits LH or RH, DART
(Apical) Tri-Bag Float Comp

Start Date: 10/17/14

Required Date: 11/07/14

D3415-041

Manufactured No

250

Each

17.0000

Start Qty: 1.00

Required Qty: 1.00

D3415-041

Nut Plate

**

B126635 all 10/16/14

Location

Loc Qty

Loc Code

ST037

17

113764

17

CCR264SS3-3

Purchased

No

250

Each

419.0000

2

2

CCR264SS3-3

Cherry Rivet

**

all 10/16/14

Location

Loc Qty

Loc Code

ST321

419

113973

26

m126282

43

m126333

66

m128636

84

m128818

200

ALS4-1032-130

ABLS4-1032-130

Purchased

No

250

Each

3,693.000

78

ALS4-1032-130

Rivnut

**

78 40 all 10/16/14

Location

Loc Qty

Loc Code

ST267

3693

M126109

57

M128211

48

M128649

3588

40

October-17-14 10:18:15 AM

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Page 5

Work Order ID: 125633

Parent Item: D206-642-541

Parent Item Name: Replacement Skidtube, High Gear, Standard Wearplates Fits LH or RH, DART
(Apical) Tri-Bag Float Comp

125633

D206-642-541

Start Date: 10/17/14

Required Date: 11/07/14

D3537-3

Manufactured No

270

Each

Start Qty: 1.00
56.0000 1 1

Required Qty: 1.00

D3537-3
Wearpad

**

lll 10/6/14

Location

Loc Qty

Loc Code

FG

8

86237

8

B126377 X1

FP001

5

111825

1

113789

1

115122

6

FP002

40

120646

40

D3537-1

Manufactured No

270

Each

28.0000

9

9

D3537-1
Wearpad

**

lll 10/6/14

Location

Loc Qty

Loc Code

FG

18

79833

8

88562

10

B126373 X9

FP001

10

113839

4

120644

5

93945

1

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Page 6

Work Order ID: 125633

125633

Parent Item: D206-642-541

D206-642-541

Parent Item Name: Replacement Skidtube, High Gear, Standard Wearplates Fits LH or RH, DART
(Apical) Tri-Bag Float Comp

Start Date: 10/17/14

Required Date: 11/07/14

NAS1149C0332R

Purchased

No

270

Each

Start Qty: 1.00
8,749.000 80

Required Qty: 1.00

NAS1149C0332R

WASHER

**

46 42

Location	Loc Qty	Loc Code
CA	83	
m129682	83	
ST278	8666	
122063	41	
125654	425	
m126319	51	
m127306	2065	
m127831	26	
m128591	75	
m129499	191	
m130325	4792	
m130466	1000	

42

NAS1149C0463R

Purchased

No

270

Each

535.0000

NAS1149C0463R

Washer

**

10/16/14

Location	Loc Qty	Loc Code
ST278	535	
119097	1	
123248	1	
123355	55	
m127306	123	
m128401	355	

25

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Page 7

Work Order ID: 125633

125633

Parent Item: D206-642-541

D206-642-541

Parent Item Name: Replacement Skidtube, High Gear, Standard Wearplates Fits LH or RH, DART
(Apical) Tri-Bag Float Comp

Start Date: 10/17/14

Required Date: 11/07/14

D3672-1

Manufactured No

270

Each

897.0000

Start Qty: 1.00

2

2

Required Qty: 1.00

D3672-1

Washer, Phenolic

**

all white

Location

Loc Qty

Loc Code

FG

10

85222

10

ST055

887

113581

466

120116

379

80369

34

99099

8

AN3C4A

Purchased

No

270

Each

881.0000

80

**

40-42 all white

AN3C4A

Bolt

Location

Loc Qty

Loc Code

FG

20

122814

20

ST350

861

124221

12

M127410

1

M127832

62

M128606

32

M128634

8

M128739

4

M128879

71

M129520

671

1130716 42

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Work Order ID: 125633

125633

Parent Item: D206-642-541

D206-642-541

Parent Item Name: Replacement Skidtube, High Gear, Standard Wearplates Fits LH or RH, DART
(Apical) Tri-Bag Float Comp

Start Date: 10/17/14

Required Date: 11/07/14

AN4C5A

Purchased

No

270

Each

93.0000

Start Qty: 1.00

Required Qty: 1.00

AN4C5A

Bolt

**

all 14/11/14

Location

Loc Qty

Loc Code

ST345

50

M130466

50

ST355

43

122599

3

123265

1

M127410

8

M128403

31

XT

D2646

Manufactured

No

270

Each

49.0000

1

**

13 126636 C/C/ all 14/11/14

D2646

Aft Cap

Location

Loc Qty

Loc Code

FG

4

85848

2

90495

2

FP001

10

103306

2

107857

1

113830

1

114495

6

FP002

35

119656

35

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Picklist Print

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Page 9

Work Order ID: 125633

125633

Parent Item: D206-642-541

D206-642-541

Parent Item Name: Replacement Skitube, High Gear, Standard Wearplates Fits LH or RH, DART
(Apical) Tri-Bag Float Comp

Start Date: 10/17/14

Required Date: 11/07/14

D3413-1

Manufactured No

270

Each

31.0000

Start Qty: 1.00

Required Qty: 1.00

1 1

D3413-1

O-Ring

★★

13126637(12) 111 44/4/2

Location

Loc Qty

Loc Code

ST525

31

106048

1

110715

11

112309

6

114489

3

114528

1

116664

1

120218

8

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Qty -041	Qty -043	Part Number	Description
X		D3274-041	SKIDTUBE ASSEMBLY
	X	D3274-043	SKIDTUBE ASSEMBLY
1	1	D2600-1-240	EXTRUSION
1	1	D2648	AFT CAP
12	12	D2649	CROSS BOLT SPACER
12	37	D3275-1	CROSS BOLT SPACER
1	1	D3282-041	FLOAT WEB
1	1	D3285-1	CAP
1	1	D3413-1	RING
1	1	D3415-041	NUT PLATE
1	1	D4956-15	WEARSHOE
1	1	D4956-23	WEARSHOE
1	1	D4956-35	WEARSHOE
1	1	D4956-39	WEARSHOE
9	9	D3537-1	WEARPAD
1	1	D3537-3	WEARPAD
78	78	ALS7-1032-130	INSERT (or AKS4-1032-130, ALS4-1032-130, AELS-1032-130)
80	80	AN3C4A	BOLT
1	1	AN4C5A	BOLT
1	1	AN960C416	WASHER
80	80	AN960C10L	WASHER
2	2	CCR264S83-3	RIVET
2	2	CR3212-4-03	RIVET
2	2	NAS1515H3L	WASHER

GENERAL NOTES:

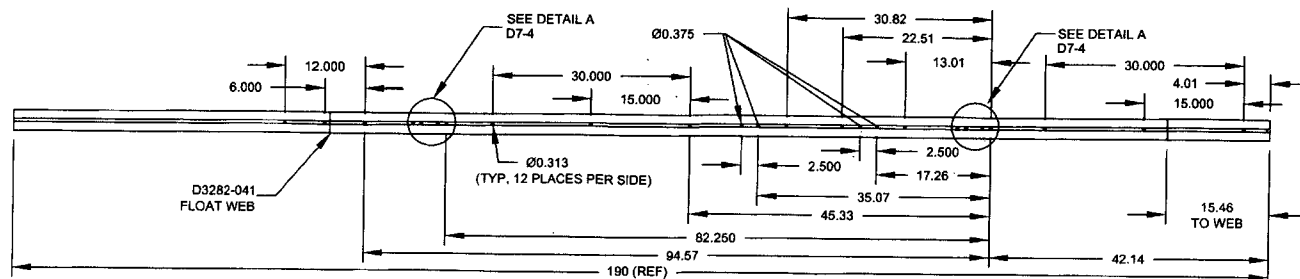
- MATERIAL: N/A
- FINISH: - CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 PRIOR TO INSTALLING D3282-041 WEB
- PRIME (REF. 4.2.1.3.3) AND PAINT WHITE PER DART QSI 005 4.2
- BLACK ANTI-SKID PAINT AS INDICATED TO 0.5" ABOVE LOCATION RIDGE PER DART QSI 005 4.4
- TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- UNITS: INCHES UNLESS OTHERWISE NOTED
- BREAK SHARP EDGES 0.005 TO 0.010 MAX
- IDENTIFICATION: N/A
- WEIGHT: 20.8 LBS
- WELDING TO BE DONE PER DART QSI 004.
- ALL HOLES DRILLED ON CENTERLINES.
- DAMAGE TOLERANCE ON FWD BEND:
THERE SHOULD BE NO VISIBLE WRINKLES IN THE BEND FROM THE GROUND TO A HEIGHT OF 7 INCHES ABOVE THE GROUND. IT IS ACCEPTABLE TO POLISH OUT GOUGES UP TO 0.020 DEEP IN THE BENT PORTION OF THE TUBE. A MAXIMUM REDUCTION IN DIAMETER OF 0.150" IS ACCEPTABLE IN THE BENT PORTION OF THE TUBE.
- BOND D3282-041 FLOAT WEB INTO D3274-1/-3 OUTER TUBE WITH NON-STRUCTURAL SIKAFLEX-241/291 ADHESIVE PER DART QSI 015. ENSURE HOLES LINE-UP.
- DRILL 20.297 HOLES FOR ALS7-1032-130 INSERTS USING DT3274-1T2 BEFORE FINISH. INSTALL ALS7-1032-130 INSERTS AFTER FINISH. SEAL WEARSHOE BOLTS WITH SIKAFLEX -241/-291.
- COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES "LPS PROCYON" AFTER FINAL ASSEMBLY. CLEAN EXCESS GREASE WITH WASH 'N WIPE DEGREASER.

F

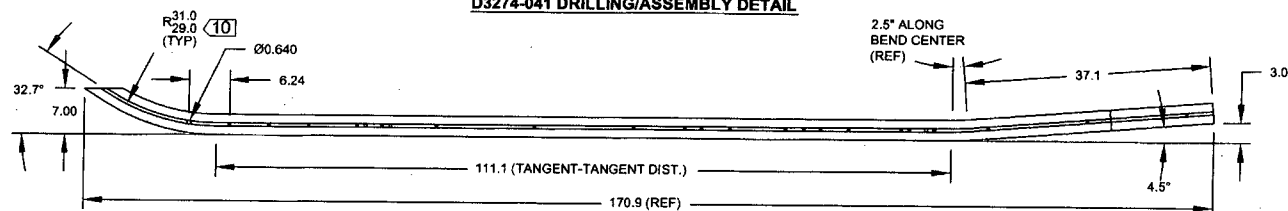
W/O 25633

RELEASED
2014-05-26
md

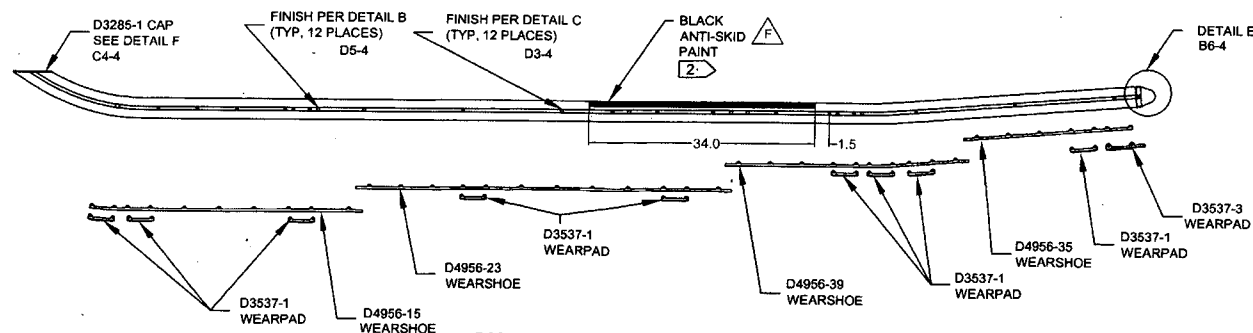
F	REVISE NOTE 2: ADD ANTI-SKID PAINT, REMOVE GASKETS PER IIN-D206-642 REV Q	DB	14.04.15
E	REVISE NOTE 2: FINISH NOW PRIME/PAINT WAS POWDERCOAT, REF. PAR13-256	DW	13.05.17
D	NEW INSERTS, SS WEARSHOE + GASKET	CP	08.12.19
C	ADD -043; NEW INSERTS	CP	05.03.16
B	MOVE SADDLE HOLE: 42.14 WAS 42.76	CP	04.08.09
A	NEW ISSUE	CP	04.03.15
REV.	DESCRIPTION	BY	DATE
DESIGN	CP	DART AEROSPACE LTD KENT, WA	
DRAWN	DB		
CHECKED	DW	DRAWING NO.	REV. F
MFG. APPR.	MD	D3274	SHEET 1 OF 4
APPROVED	MD	TITLE	SCALE
DE APPR.	MD	SKIDTUBE ASSEMBLY	NTS
DATE	14.04.15	COPYRIGHT ©2004 BY DART AEROSPACE USA, LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR REPRODUCED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, LTD	



D3274-041 DRILLING/ASSEMBLY DETAIL



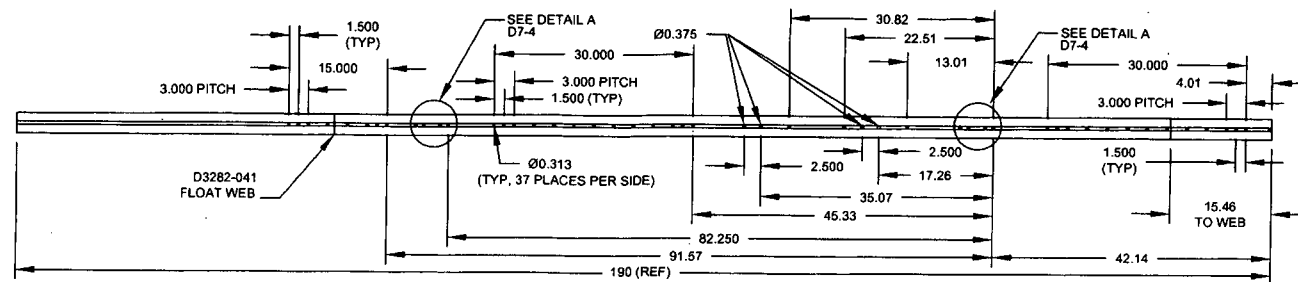
D3274-041 BEND/DRILLING DETAIL



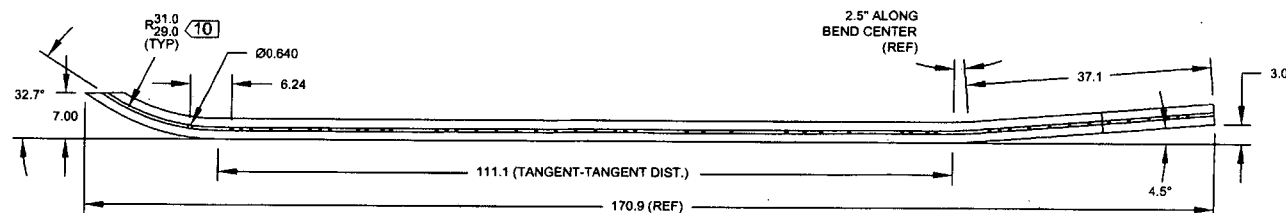
**D3274-041 SKIDTUBE ASSEMBLY
(SEE DETAIL D FOR WEARSHOE INSTALLATION)**

RELEASED
2014-05-26

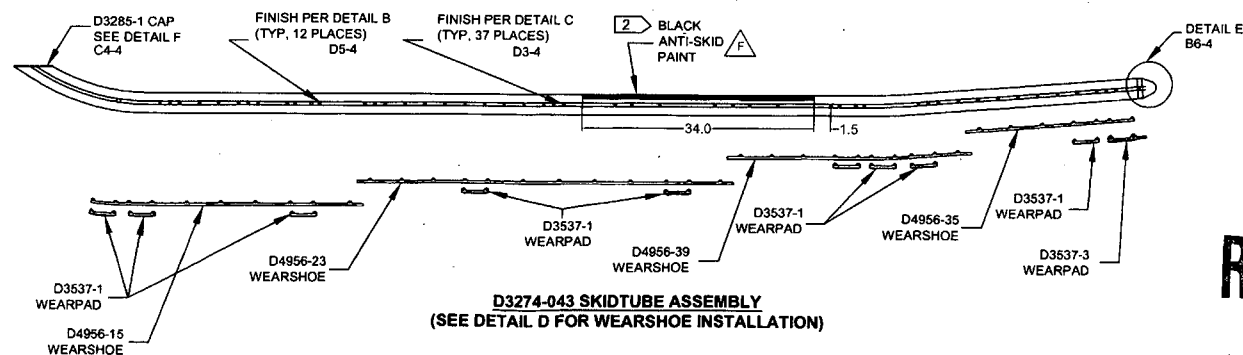
DESIGN	CP	DART AEROSPACE LTD	
DRAWN	DB	KENT, WA	
CHECKED	<i>DW</i>	DRAWING NO.	REV. F
MFG. APPR.	<i>DB</i>	D3274	SHEET 2 OF 4
APPROVED	<i>DB</i>	TITLE	SCALE
DE APPR.	<i>DB</i>	SKIDTUBE ASSEMBLY	NTS
DATE	14.04.15	<small>COPYRIGHT ©2004 BY DART AEROSPACE USA, LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, LTD.</small>	



D3274-043 DRILLING/ASSEMBLY DETAIL



D3274-043 BEND/DRILLING DETAIL

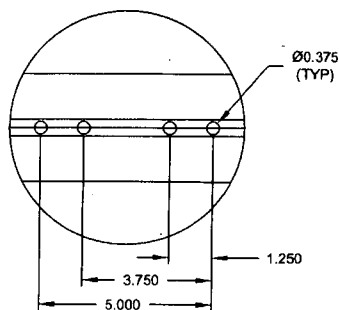


**D3274-043 SKIDTUBE ASSEMBLY
(SEE DETAIL D FOR WEARSHOE INSTALLATION)**

RELEASED
2014-05-26

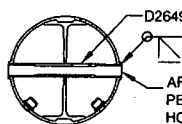
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DRAWN	DB	KENT, WA	
CHECKED	DB	DRAWING NO.	REV. F
MFG. APPR.		D3274	SHEET 3 OF 4
APPROVED		TITLE	SCALE
DE APPR.		SKIDTUBE ASSEMBLY	4.04.15
DATE	14.04.15	COPYRIGHT ©2004 BY DART AEROSPACE USA, LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESSED CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, LTD	

DETAIL A: DRILL DETAIL
D6-2, D3-2, D5-3, D3-3



DETAIL B
B6-2, B5-3

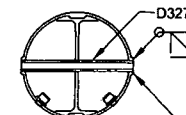
FOR Ø0.375 HOLES ONLY



- AFTER DRILLING AND BENDING ASSEMBLY
PERFORM THE FOLLOWING FOR Ø0.375
HOLES ONLY:
1. CHAMFER HOLE 0.030x45°
 2. INSERT D2649 SPACER
 3. WELD INTO PLACE AND GRIND FLUSH
 4. C BORE TO Ø0.313x0.75 DEEP

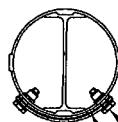
DETAIL C
B5-2, B4-3

FOR Ø0.313 HOLES ONLY



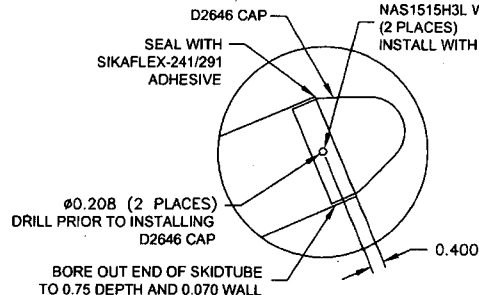
CHAMFER 0.030x45°
(TYP)

DETAIL D
A4-2, A4-3

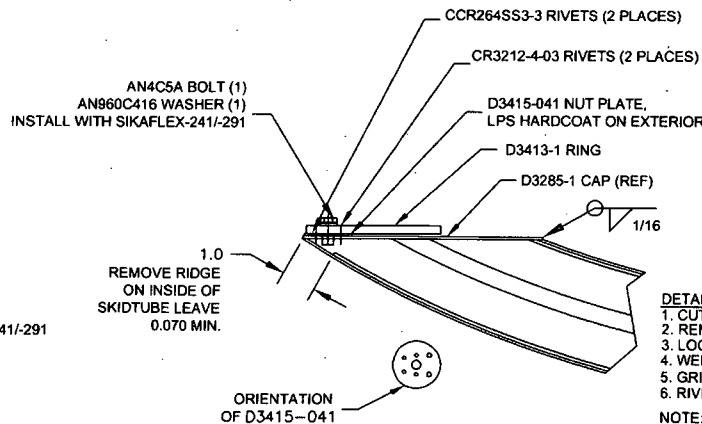


- ALS7-1032-130 INSERT (1)
AN3C4A BOLT (1)
AN960C10L WASHER (1)
(78 PLACES)
GASKET/WEARSHOE/WEARPAD (REF)

DETAIL E
B2-2, B2-3



DETAIL F: END FINISHING DETAIL
B7-2, B7-3



- DETAIL F NOTES**
1. CUT TUBE LEVEL
 2. REMOVE RIDGE ON FWD SIDE
 3. LOCATE D3285-1 (TRIM AS NECESSARY)
 4. WELD D3285-1 IN PLACE PER DART QSI 004
 5. GRIND FLUSH
 6. RIVET D3415-041 NUT PLATE IN PLACE
- NOTE: MASK THREADS IN D3415-041
PRIOR TO FINISH

RELEASE
2014-05-26

DESIGN	CP	DART AEROSPACE LTD	
DRAWN	DB	KENT, WA	
CHECKED		DRAWING NO.	REV. F
MFG. APPR.		D3274	SHEET 4 OF 4
APPROVED		TITLE	SCALE
DE APPR.		SKIDTUBE ASSEMBLY	NTS
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